

# PRELIMINARY ISSUE

Work Order ID 64162

Thursday, November 25, 2010 4:02:19 PM

Page 1

Item ID: D4298-006

Accept

Revision ID: PRELIM

Item Name: Machined Inner Assembly

Start Date: 11/25/2010 Start Qty: 1.00

Required Date: 12/3/2010 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:



Approvals:

Process Plan:

Date: 10-11-24 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4298

PA1

100

0.00



Bandsaw

Memo

0.00

amk 10/12/07

Jeaspa Bandsaw

105

0.00



HAAS 1

Memo

0.00

amk 10/12/07

HAAS CNC vertical machine #1

mill - 018 9/10/12/07

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

amk 10/12/07

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Thursday, November 25, 2010 4:02:19 PM



**Accept**

**Setup Start**

**Stop**



**Start Date:** 11/25/2010    **Start Qty:** 1.00

**Cust Item ID:**

**Required Date:** 12/3/2010      **Req'd Qty:** 1.00



**Customer:**

**Reference:**

Run Start



**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

**Stop**



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

0.00 - inspector to Envt



QC

## Memo

0,00

## Quality Control

0.00



HandFinish

## Memo

0.00

## Hand Finishing

0.00



### Powdercoat

## Memo

0.00

## Powder Coating

POWDER COAT:

Start Time: 9:05

Oven Temperature: 325

Finish Time: 0.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 64162**

Thursday, November 25, 2010 4:02:19 PM



Page 3

Item ID: D4298-006  
Revision ID: PRELIM  
Item Name: Machined Inner Assembly

Accept



Setup Start



Stop



Start Date: 11/25/2010 Start Qty: 1.00  
Required Date: 12/3/2010 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

*ll**10/12/09*

0.00

Memo

*1 0*

160



Small Fab

Small Fab

Memo

1- Assemble as per dwg

0.00

0.00

*25/10/12/15 @*

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 64162**

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Page 4

Item ID: D4298-006

Accept

Setup Start

Revision ID: PRELIM

Item Name: Machined Inner Assembly

Stop

Start Date: 11/25/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 12/3/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

POSITIVE RECALL

EFFECTIVE 10.11.29 AUTH

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Page 1

Thursday, November 25, 2010 4:02:23 PM

Work Order ID: 64162

Parent Item: D4298-006

Parent Item Name: Machine Inner Assembly

Start Date: 11/25/2010

Required Date: 12/3/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP revA 10.11.24 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6B0.750X01.00  
0

Purchased

No

100

f

40.0000

0.28

0.294737



6061-T6 Bar .750 x 1.00



SL 10/11/07

Location

Loc Qty

Loc Code

MAT02

40

112567

40

30

D4298-024

Manufactured

No

160

Each

0.0000

1

1



Serrated Adjustment Washer

MS20426AD3-16

Purchased

No

160

Each

5,984.000

1

1



SB 10/12/15

RIVET

10.12.15

Location

Loc Qty

Loc Code

ST316

5984

104374

1984

110398

4000

M105055

1 SB 10/12/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

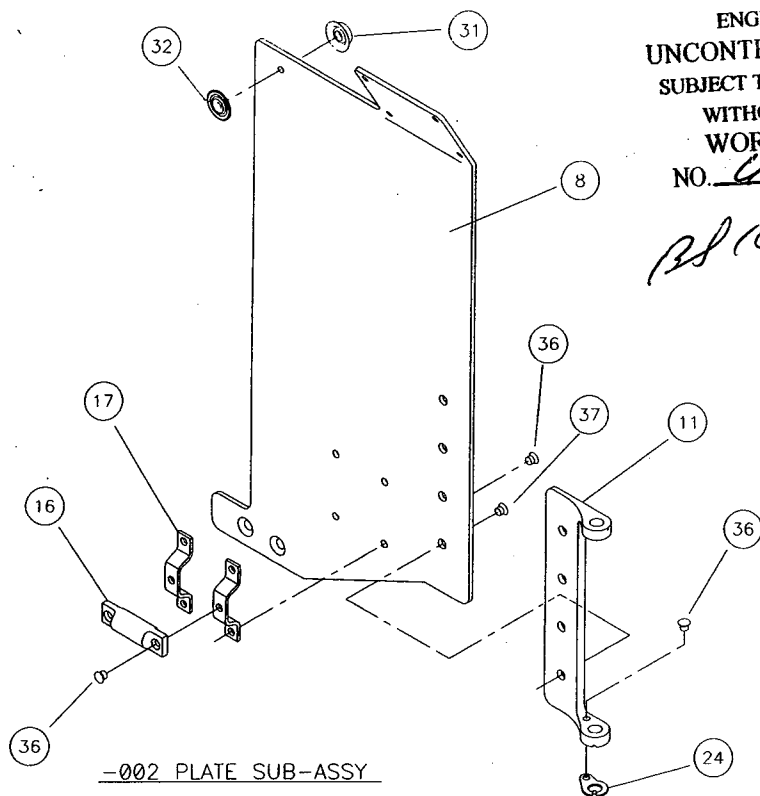
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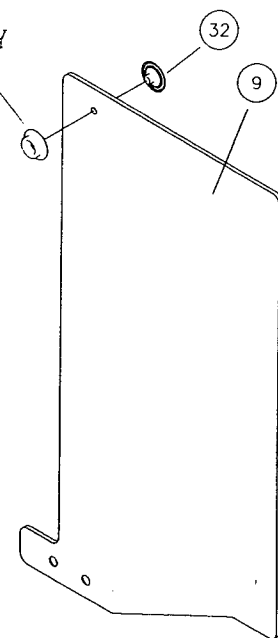


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 WITHOUT NOTICE  
 WORK ORDER  
 NO. 64162

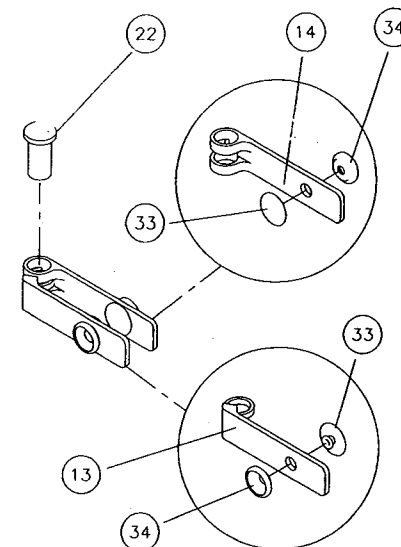
BS10-11-26



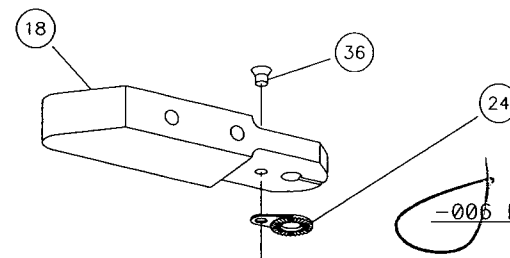
-002 PLATE SUB-ASSY



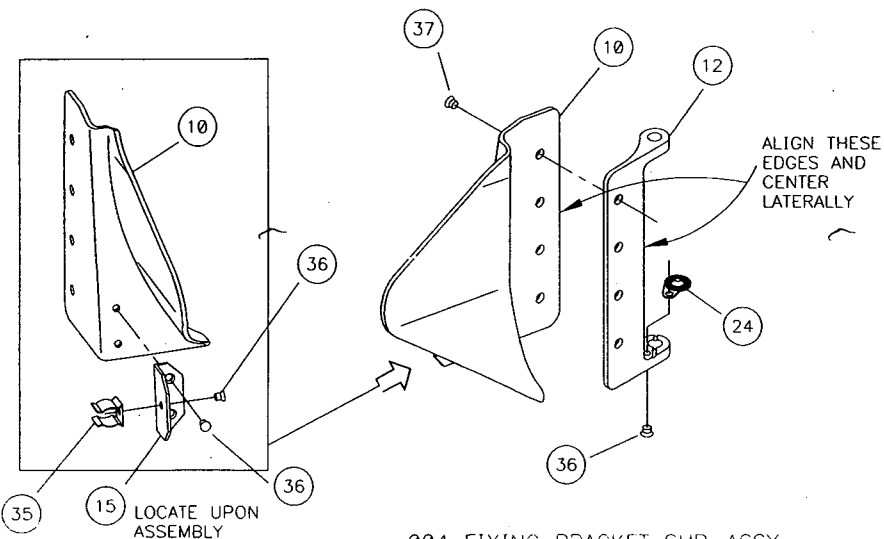
-003 PLATE SUB-ASSY



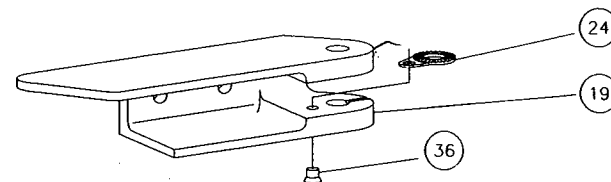
-005 HINGE SUB-ASSY



-006 MACHINE INNER SUB-ASSY



-004 FIXING BRACKET SUB-ASSY

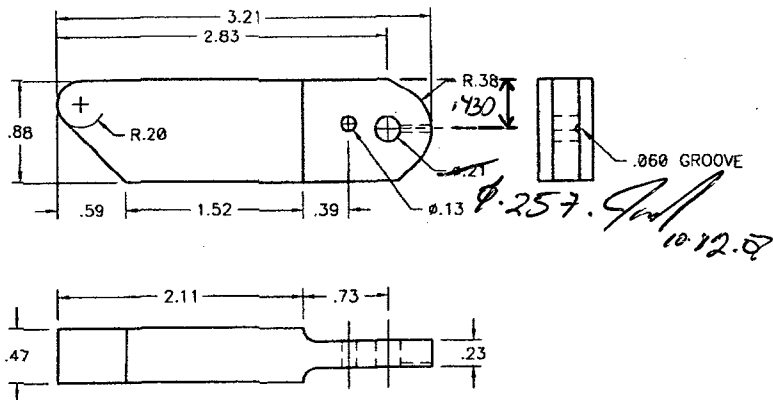


-007 MACHINE OUTER SUB-ASSY

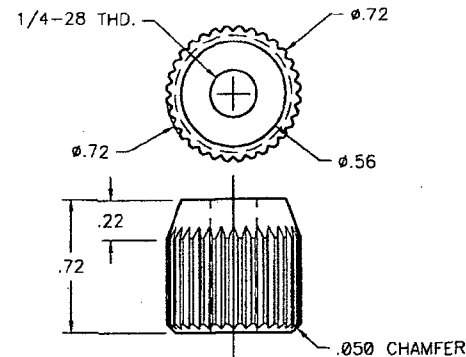
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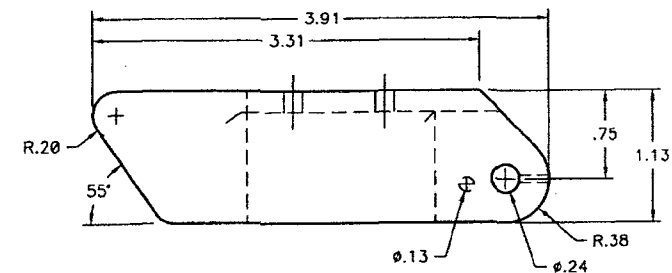
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			13939-1-290	



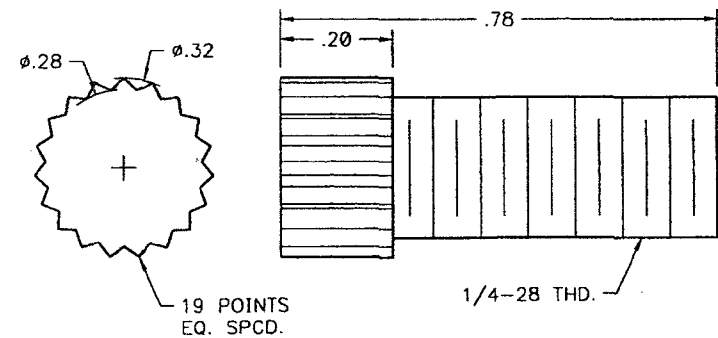
-018 MACHINED INNER



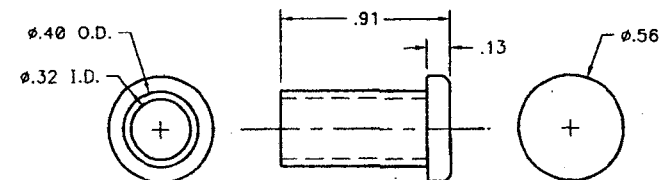
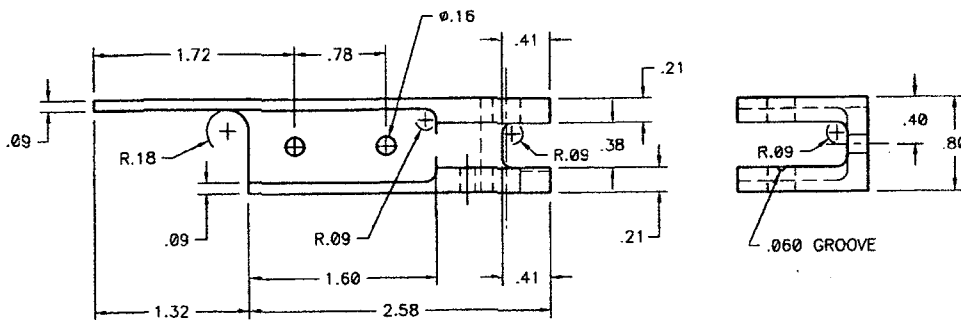
-020 KNOB



-019 MACHINED OUTER



-021 MACHINED BOLT



-022 PIN TOPPER

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TITLE SINGLE PILOT VFR  
CHART HOLDER, AW139

SIZE C

DWG. NO. 13939-1-290  
SHT 9 OF 10

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